Work Order ID 57356  April 6, 2010 8:56:17 AM							*	2018		Page 1
Item ID: D206-642-541  Revision ID: Item Name: Replacement Skidtube		Accept					Setup	Start Stop	i inniiiùi d	
Start Date:         06/04/2010         Start Qty: 1.00           Required Date:         16/04/2010         Req'd Qty: 1.00           Reference:         16/04/2010         Req'd Qty: 1.00			Cust Item I Customer:	D:					1 100)))(0 1	<b>1816                        </b>
Approvals: Process Plan: QC:	Date: 10-4-06 Date:	Tooling: SPC (Y/N):		ate:	-		Run	Start Stop		
Sequence ID/ , Operation Work Center ID Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr Revision Nbr  D3274 D  IIN-D206-642 Rev M										
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0.00

Photocopy bluefile & type labels per PPP D206-642-541

Memo

Document Control

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April 6, 2010 8:56:17 AM



Page 2

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name: 🏂 Replacement Skidtube

**Start Date:** 

06/04/2010

Start Qty: 1.00

**Required Date:** 16/04/2010 Req'd Qty: 1.00



Cust Item ID:

**Customer:** 

Reference:

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Process Plan: \_\_\_\_\_ Date:

Tooling:

Date:

Run

Start

Stop

Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Stop



Sequence ID/ Work Center ID

110



Skidtubes Skidtubes

Description

**Run Hours** 0.00

Draw Number Draw Rev.

Plan Code Accept **Qty** 

Reject Qty

Reject

Number Stamp

Skidtubes

Operation

Memo

0.00

\*\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd W\0/4/7 end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 1250 7

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A.B.C.D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #:--

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BG 10/04/14

WV1 04-15

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W/O:		WORK ORDER CHANGES								
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April 6, 2010 8:56:17 AM Item ID: D206-642-541 **Revision ID:** Replacement Skidtube Item Name: **Start Date:** 06/04/2010 **Required Date:** 16/04/2010 Reference: QC: Sequence ID/ **Work Center ID** 120

Accept

Setup Start

Stop

**Cust Item ID:** 

**Customer:** 

Approvals:	Process Plan:	

**Tooling:** Date:

Date:

Run Start



Date: SPC (Y/N): Date:

Stop



HandFinish

Hand Finishing

Operation Description

Start Qty: 1.00

Req'd Qty: 1.00

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 0.00

Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Memo

Memo

QC5- Inspect part completeness to step on W/O

0.00

130

OC

Quality Control

QC3- Inspect Part Finish

0.00

140

Quality Control

0.00

Memo

0.00

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W/O:			WORK ORDER CHANG					3					
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### Work Order ID 57356

April 6, 2010 8:56:17 AM



Page 4

Item ID:

D206-642-541

Accept



Setup Start



**Revision ID:** 

Item Name:

Replacement Skidtube

**Cust Item ID:** 

Stop

Start Date:

06/04/2010 **Required Date:** 16/04/2010 Start Qty: 1.00 Req'd Qty: 1.00

**Customer:** 

Reference:

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Process Plan:

Date:

**Tooling:** 

Date:

Run

Start



OC:

Date:\_ SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**  Operation **Description** 

Set Up/ **Run Hours**  Draw Number

Draw Plan Rev. Code

Accept **Qty** 

Reject Qty

Reject Insp. Number Stamp

150

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg

D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015. A/RDDSikaflex-291D M 112 429 DD

Sikaflex expire date: 0/8/30 0
Start: 0/2/07 Time: 0 / 5 0
Finish: 0/5/5 0 Time: 0/03/0

(Adhere for 12 hours)

M1014/19

M 10/41127

160

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

# DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector

Part No	:	PAR #:	Fault Ca	ntegory:	NCR: Yes N	o <b>DQA</b> :	Date: _	
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April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010

Page 5

Item ID: **Revision ID:** 

D206-642-541

Accept



Setup Start



Item Name:

Replacement Skidtube

06/04/2010

QC:

Start Qty: 1.00 Reg'd Oty: 1.00

**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

**Start Date:** 

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Process Plan:

Date:

Tooling:

Date:

Rev.

Run

Start

Stop

Stop



Sequence ID/

**Work Center ID** 

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Draw

Plan Code

Accept Reject **Qty** Oty

Reject Number Stamp

Insp.

170



Skidtubes

Skidtubes

Operation Description

Memo

Skidtubes

Set Up/ **Run Hours** 

0.00

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2

OPEN HOLES TO .297". Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

QC5- Inspect part completeness to step on W/O

Memo

10-05-10

180



Quality Control

W/O:			W	ORK ORDER CHANG	iES				. 1
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#### Work Order ID 57356

April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010



Page 6

Item ID:

D206-642-541

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: **Start Date:** 

Replacement Skidtube

06/04/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

A	
Approvals:	

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

0.00

Date:

Date:

Run

Start Stop

Sequence ID/

Operation **Description** 

Skidtubes

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

**Work Center ID** 190

Skidtubes Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use

aluminum rod A/R - Aluminum Rod M/ 2507

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

Plan

M10/5/13

200

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

W/O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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<u> </u>							, <u>,,,,</u>

Part No: 1206-642-54 PAR #: \_\_\_ Fault Category: Skilling NCR: Yes No DQA: \_\_\_ Date: 1005/3

Resolution: \_\_\_\_\_\_\_ Disposition: \_\_\_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_\_\_ Date: 10 06 17

NCR: 5	7356	W	ORK OR	DER NON-CONFORMANCE	E (NCR)			
		Description of NC		Corrective Action Section B				Annuarial
DATE STEP		Section A	Initial Action Description Sign & Chief Eng Date		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
Wola	H 190	After welding it was Pours that the x-butta D3075-1 is too short. Love side is Fully welded on the 15t Aft hole.	psun	-Gr. no who well Flush -Drill out affector to bult open (1st From AFT) - leploe D3275-1 B=58179	BG 1905/2	Colubo	Posure	Sulstia
		12.4 Spec 03275-1358179 was mochin to short	psion	- re well ner as zwy	10/05/12	Solorbo	psinz	Sulvala

## Work Order ID 57356

April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010



Page 7

Item ID:

D206-642-541

Accept



Setup Start



Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

06/04/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

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Date:

Tooling:

0.00

0.00

Date:

Run

Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID

210



**Quality Control** 

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**  Draw Number

· 10/07/13

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

220



Hand Finishing

230



Powder Coating

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

Realodine tube as per QSI 005 Section 4.1.2.1 do not acid etch

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1114207

0.00

Jel 10/05/17

DBL 10-5-14.

Memo

START TIME: 9.00 AM OVEN TEMPERATURE: FINISH TIME:

W/O:			W	ORK ORDER CHANG	ES		*	· .	4
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#### Work Order ID 57356

April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010



Page 8

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

**Start Date:** 

06/04/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

Customer:

Draw

Number

Reference:

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Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run

Start

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_

Draw

Rev.

Plan

Code

Sequence ID/ Work Center ID

240

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours** 

0.00

0.00

0.00

Accept Qty Qty

Reject

Reject Number Stamp

Insp.

bk 16-5-20 0.00 Memo

250

HandFinishing

HandFinish Hand Finishing

Memo

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R \( \text{N/A} \text{DLPS-3} \) \( \text{LPS-3} \

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

Sikaflex expire date:

A/R□Sikaflex-291 □ //2~/3 %

WL 10-5-20.

260

Quality Control

QC5- Inspect part completeness to step on W/O

Inspect Nut Plate & Inserts

Memo

W/O:			V	VORK ORDER CHANG	GES			<del></del>	g 2
DATE	STEP	PRO	PROCEDURE CHANGE				ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 5735	Work	Order	ID	573	56
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April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010



Page 9

Item ID:

D206-642-541

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name: Replacement Skidtube

06/04/2010

Start Qty: 1.00

Reg'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

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Process Plan: \_\_\_\_\_ Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date:\_\_\_ SPC (Y/N): Date:

Stop



Sequence ID/ **Work Center ID** 

270

HandFinish

Hand Finishing

Operation Description

Set Up/

**Run Hours** 0.00

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

HAND FINISHING RESOURCE #1

Memo

0.00

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D8274 A/R□□Sikaflex-291 □

Sikaflex expire date:

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch:

5-Install Aft Cap and seal with Sikaflax Clean excess adhesive. A/R \Bigcip Sikaflex-291 \Bigcip \Bigc

Sikaflex expire date:

YON BLACK 104251

1) BK 10-5-20.

280

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

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W/O:	V/O:			WORK ORDER CHANGES							
DATE	STEP	PROC	CEDURE CH	CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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#### Work Order ID 57356

April 6, 2010 8:56:17 AM

**Required Date:** 16/04/2010



Page 10

Item ID:

D206-642-541

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

06/04/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

**Tooling:** 

Date:

Start Run



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** 

290

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

Set Up/ Run Hours Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

300

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/17 H

W/O:			V	VORK ORDER CHANG	GES	····		•	· · · · · · · · · · · · · · · · · · ·
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Pickiist Print April 6, 2010-8:56:										Pa
Work Order ID: 57  Parent Item: D2  Parent Item Name:  Comments:	7356  206-642-541  Replacement Skidt  IPP Rev:B□05.09.  IPP Rev:C 07-02  IPP Rev:D 07-12  IPP Rev:E 08-0	23 Revised per D2 2-23 Added SS W 2-06 replace NAS	06-642 F Vearplates					tart Date: (Start Qty:	06/04/2010 1.00	Required Date: 16/04/20 Required Qty: 1.00
D2600-1-190		Manufactured	No	·	110	Each	50.0000	1.0000		
Cap		Manufactured	No	Warehouse Location  Main Warehouse LG  47575	<u>Lo</u> \ 110	50 50 Each	Loc Code 164.0000	1.0000		y107477
03282-041		Manufactured	No	Warehouse Location Main Warehouse LG 47635 52511 52647	<u>Lo</u>	164 15 74 75 Each	<u>Loc Code</u> 4.0000	1.0000	/	- - & E1404/14
Float Web (206L/407)				Warehouse Location  Main Warehouse LG 52696	<u>Lo.</u>	2 Oty 4 4	Loc Code			_
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W/O:			V	VORK OR	DER CHA	NGES					• •
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**Required Date: 16/04/2010** 

Required Qty: 1.00

April 6, 2010 8:56:21 AM

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM IPP Rev:C 07-02-23

IPP Rev:D 07-12-06

IPP Rev:E 08-04-17

Added SS Wearplates & Gaskets JLM□ replace NAS1515H3L to D3672-1 DD

as per PAR 08-015 DD verified by:EC

D2649

Manufactured

Manufactured

Purchased

No

No

No

190

Each

85.0000

**120000** 

Start Date: 06/04/2010

Start Qty: 1.00

Cross Bolt Spacer

Warehouse Location Main Warehouse

LG

55000

Loc Qty

85 190 Each

85

Loc Code

**2**0.0000

Loc Code

12.0000

Crossbolt Spacer

D3275-1

Warehouse

Location

Main Warehouse

LG

53453

Loc Oty

20

20 250 Each

219.0000 2.0000

CR3212-4-03

Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311 111359

112314

219 92

127

April 6, 2010 8:56:21 AM

**Shop Packet Print** 

Page 2

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	IANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										·			
Part No	:	PAR #:	Fault Ca	tegory:		_ NCR:	Yes N	lo <b>DQ</b>	4:	Date:			
	Resolution: Disposition:												
NCR:		V	VORK OR	DER NO	N-CONFORMA	ANCE (	NCR)	<del></del>					
DATE	STEP	Description of NC	Corrective Action Secondarial Action Description			on B	N: 0	Verific	erification	Approval	Approval		
		Section A	Chief Eng	ACT	Chief Eng	,	Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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#### Picklist Print

April 6, 2010 8:56:21 AM

Page 3

Required Date: 16/04/2010

Required Qty: 1.00

Work Order ID: 57356

D206-642-541



Parent Item Name:

Replacement Skidtube

**Comments:** 

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23 IPP Rev:D 07-12-06

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

No

No

IPP Rev:E

08-04-17

as per PAR 08-015 DD verified by:EC

Manufactured No

Purchased

Purchased

250

250

Each

75.0000 1.0000

Start Date: 06/04/2010

Start Qty: 1.00

Nut Plate

D3415-041

Warehouse Location Main Warehouse

ST056

33842

75 75 Each

Loc Qty

726

Loc Oty

726.0000 2.0000

Loc Code

Loc Code

CCR264SS3-3

Cherry Rivet

Warehouse Location Main Warehouse

ST311 111548

112314 113539 113973

92 626 250 Each

40.0000 78.0000

ALS4-1032-130

Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282 //4654 110511

40

40

78. Pf 10-5-20

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							<u> </u>					
Part No	:	PAR #:	Fault Cat	tegory:	NCP: You	No DO	۸.	Dete				
		esolution:										
NCR:				DER NON-CONFORM			121.					
DATE	STEP	Description of NC		tion B	Verific	eation	Approval	Approval				
	0.21	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o	& Secti		Chief Eng	QC Inspector			
									-			
					-				i			
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#### Picklist Print

April 6, 2010 8:56:21 AM

Page 4

**Required Date: 16/04/2010** 

Required Qty: 1.00

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23 IPP Rev:D

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:E

07-12-06 08-04-17

as per PAR 08-015 DD verified by:EC

D3536-15

Manufactured No

Manufactured

Manufactured

No

270

Each

19.0000

1.0000

Start Date: 06/04/2010

Start Oty: 1.00

Gas

11110 1000 11101 01100 11110 0111 110EE1 11EUI 0111 1EUI	
sket	

	Warehouse	Loc	: Oty	Loc Code	<u>!</u>	
	<b>Location</b>					
	Main Warehouse					
	FP		19			
	51600		7		•	
	56055		12			= bk/0-6-20
No		270	Each	7.0000	1.0000	·



Gasket

Warehouse	Loc (	<u>)ty</u>	Loc Code	
Location				
Main Warehouse				
FP 57529		7		
53468		7		
	270	Each	11.0000	1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

11 11 1 \$ 10-5-00

1 8/10-5-20

W/O:			N	ORK ORDER CHANG	SES		4	• •
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA: _	Date: _	
		solution:						
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCF	₹)	1	
DATE	STEP	Description of NC				Verification	n Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date		Chief Eng	QC Inspector
								-
								-

#### **Picklist Print**

April 6, 2010 8:56:21 AM

Page 5

Required Date: 16/04/2010

Required Oty: 1.00

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

**Comments:** 

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:D 07-12-06 IPP Rev:E

08-04-17

as per PAR 08-015 DD verified by:EC

D3536-39

No Manufactured

Manufactured

No

270

Each

11.0000 1.0000

Start Date: 06/04/2010

Start Qty: 1.00

Gasket

		Warehouse	Lo	c Qty	Loc Code	
		<b>Location</b>				
		Main Warehouse				
		FP		11		
		48161 51637 <b>V</b>		1		
		51637 <b>V</b>		10		
Manufactured	No		270	Each	14.0000	1.0000
•						



Wearshoe

D3535-15

Warehouse	Lo	oc Qty	Loc Code	
Location				
Main Warehouse				
FP		14		
53462		4		
53462 56053 <b>/</b>		10		
	270	Each	9.0000	1.0000

D3535-35

Wearshoe

Warehouse Loc Qty Loc Code Location

51608

9

9

V Bf 10-5-20.

	•								
W/O:			WC	RK ORDER CHANG	ES	A Commission of the Commission			• •
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
				;					
Part No		PAR #:							
	R	esolution:						Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC		ion B	Verifica		Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector
		<b>.</b>							-
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## **Picklist Print**

April 6, 2010 8:56:21 AM

Page 6

**Required Date: 16/04/2010** 

Required Qty: 1.00

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

Manufactured

Manufactured

Manufactured

IPP Rev:D 07-12-06

IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM□ replace NAS1515H3L to D3672-1 DD

No

IPP Rev:E

08-04-17

as per PAR 08-015 DD verified by:EC

270

Each

9.0000

1.0000

**Start Date:** 06/04/2010

Start Qty: 1.00

Wearshoe

D3535-39

	<u>Warehouse</u>	<u>Lo</u>	c Oty	Loc Code	
	<b>Location</b>				
	Main Warehouse				
	FP ./		9		
	51619		9		
No		270	Each	14.0000	1.0000

D3535-23

Wearshoe

D3537-3

Wearpad

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
FP	14	

No

2 12

270

20.0000 1.0000

Loc Otv

Each

Loc Code

Location

Warehouse

Main Warehouse

35697

20 20

\_1 Bl 15-5-00.

1 1/2 15-20

W/O:		,	V	ORK ORDER CHAN	GES		· · · · · · · · · · · · · · · · · · ·			* *
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						•				
Part No		PAR #:	Fault Ca	tegory:	NCR	: Yes 1	lo DQA	\:	Date:	
_		esolution:								
NCR:		, <b>V</b>	VORK OR	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Secondarion Description	ction B	Sign &	Verific Section		Approval Chief Eng	Approval
		OSSIGNA	Chief Eng	Chief Eng		Date	Secu	on C	Chief Eng	QC Inspector
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## Picklist Print

April 6, 2010 8:56:21 AM

Page 7

**Required Date: 16/04/2010** 

Required Qty: 1.00

9 ff 10-5-20.

Work Order ID: 57356

Parent Item:

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:D IPP Rev:E

07-12-06 08-04-17

as per PAR 08-015 DD verified by:EC

D3537-1

Manufactured No 270

Each

51.0000

9.0000

Start Date: 06/04/2010

Start Qty: 1.00

Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

51 51

Each

80.0000

AN960C10L

washer

AN960C416

Purchased

Purchased

No

N45 1149 C033 2R

270

Each

377.0000 1.0000

0.0000

washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346 100993 377 377 1 /bl 10-5-20.

W/O:	•		WC	RK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		• •			•					
		• /					•-			
		^					•			
									J	
Part No	:	PAR #:	Fault Cate	gory:	_ NCI	R: Yes	No DQA	\:	Date:	
		esolution:								
NCR:		\	WORK ORDI	ER NON-CONFORMA	ANCE	(NCR	)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		ation	Approval	Approval
	J	"Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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## Picklist Print

April 6, 2010 8:56:21 AM

Page 8

**Required Date: 16/04/2010** 

Required Qty: 1.00

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

Purchased

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM 07-12-06

No

IPP Rev:D IPP Rev:E

08-04-17

replace NAS1515H3L to D3672-1 DD as per PAR 08-015 DD verified by:EC

D3672-1

Manufactured No

270

Each

1,589.000 2.0000

Start Date: 06/04/2010

Start Qty: 1.00

Phenolic Washer

Warehouse	<u>1</u>	oc Oty	Loc Code	
<b>Location</b>				
Main Warehouse				
ST077		1589		
47628	•	89		
51674		500	•	
52505		1000		
	270	Each	1,249.000 80.0000	,

AN3C4A

**BOLT** 

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

1249 113226 248 114103 501 114108 500

80 R/10-5-20

April 6, 2010 8:56:21 AM

**Shop Packet Print** 

Page 8

W/O:			WC	RK ORDER CHANG	ES		<u> </u>	* *
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	):	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description	Sign 8	Verificatio Section C	n Approval Chief Eng	Approval QC Inspector
			Officer Ering	Chief Eng	Date			-
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## Picklist Print

April 6, 2010 8:56:21 AM

Page 9

Work Order ID: 57356

Parent Item:

D206-642-541

Parent Item Name:

IPP Rev:E

Replacement Skidtube

Comments:

IPP Rev:C 07-02-23 IPP Rev:D 07-12-06

08-04-17

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM Added SS Wearplates & Gaskets JLM

replace NAS1515H3L to D3672-1 DD as per PAR 08-015 DD verified by:EC

**Start Date:** 06/04/2010

Start Qty: 1.00

Required Date: 16/04/2010

1 / 10-5-20

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

534.0000 1.0000

**BOLT** 

Warehouse Loc Oty Loc Code Location Main Warehouse ST346 534 110552 34 112243 500 Manufactured No

Aft Cap

D2646

270

Each

35.0000 1.0000

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
FP6	28	
52663	28	
Main Warehouse		
fp7	7	
52663	7	

1 bl 10-5-20.

W/O:			WC	RK ORDER CHANG	ES			<u> </u>	* A
DATE	STEP	PR	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				····					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA		Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	?)			
DATE	STEP	Description of NC	Description of NC Corrective Action			Verifica	Verification		Approval
	<b></b>	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date		Section C		QC Inspector
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## **Picklist Print**

April 6, 2010 8:56:21 AM

Page 10

**Required Date: 16/04/2010** 

Required Qty: 1.00

Work Order ID: 57356

D206-642-541

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:D 07-12-06

IPP Rev:E 08-04-17

as per PAR 08-015 DD verified by:EC

D3413-1

Manufactured No 270

Each

31.0000 1.0000

**Start Date:** 06/04/2010

Start Qty: 1.00

Ring

Warehouse	Loc Oty	Loc Code	
<b>Location</b>			
Main Warehouse		1 ff 10-5	-20.
ST473 58524	31		
51586	8		
53446	23		

-									
	,	W	ORK ORDER CHANG	GES					<b></b>
STEP	PROCEDURE CHANGE By				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
•	PAR #-	Fault Cate	Many	NCD	· Vaa	No DO	<u> </u>	Doto	
STEP	Description of NC Corrective Action			Section B Verific			ation	Approval	Approval
Section A	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date			Chief Eng	QC Inspector
									-
								!	
		:PAR #: Resolution: STEP Description of NC	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Secti	PAR #: Pault Category: NCR  Resolution: Disposition: QA:  WORK ORDER NON-CONFORMANCE  STEP Description of NC	STEP PROCEDURE CHANGE By  PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes    Resolution: Disposition: QA: N/C Clo  WORK ORDER NON-CONFORMANCE (NCR  STEP Description of NC Section A Section B Sign & Sig	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ/ Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Verific Section A Section B Sign & Section A Section B Sect	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr    PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)    STEP   Description of NC



	DESIG	CP	DRAWN BY	DART AEROSPACE USA, INC.
	CHEC	(ED 1	APPROVED #	DRAWING NO. REV. D
ı			<del></del> #	D3274 SHEET 1 OF 4
	DATE			TITLE SCALE
	06.1	2.19		SKIDTUBE ASSEMBLY NTS
	Α		04.03.15	NEW ISSUE
	В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
	С		05.03.16	ADD -043; NEW INSERTS
	D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET



Qty -041	Qty -043	Part Number	Description	
X		D3274-041	SKIDTUBE ASSEMBLY	
	Х	D3274-043	SKIDTUBE ASSEMBLY	
1	1	D2600-1-240	EXTRUSION	
1	1	D2646	AFT CAP	
12	12	D2649	CROSS BOLT SPACER	FOP COP P
12	37	D3275-1	L CROSS BOLT SPACER	
1	1	D3282-041	1 FLOAT WEB	ETURN TO
1	1	D3285-1	CAP	GINEERING
1	1	D3413-1	RING	TROLLED COP
1	1	D3415-041		TO AMENDMEN
1	1	D3535-15	IMENDENDE	
1	1	D3535-23		HOUT NOTICE
1	1	D3535-35	WEARSHOE	RK ORDER
1	1	D3535-39	WEARSHOE NO	57359
1	1	D3536-15	GASKET	BS10-41-
1	1	D3536-23	GASKET	11/10-41
1	1	D3536-35	GASKET	19010
1	1	D3536-39	GASKET	<i>r</i>
σ	9	D3537-1	WEARPAD	
1	1	D3537-3	WEARPAD	
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	
80	80	AN3C4A	BOLT	
1	1	AN4C5A	BOLT	
1	1	AN960C416	WASHER	
80	80	AN960C10L	WASHER	
2	2	CCR264SS3-3	RIVET	

#### **GENERAL NOTES:**

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

CR3212-4-03

NAS1515H3L

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.

RIVET

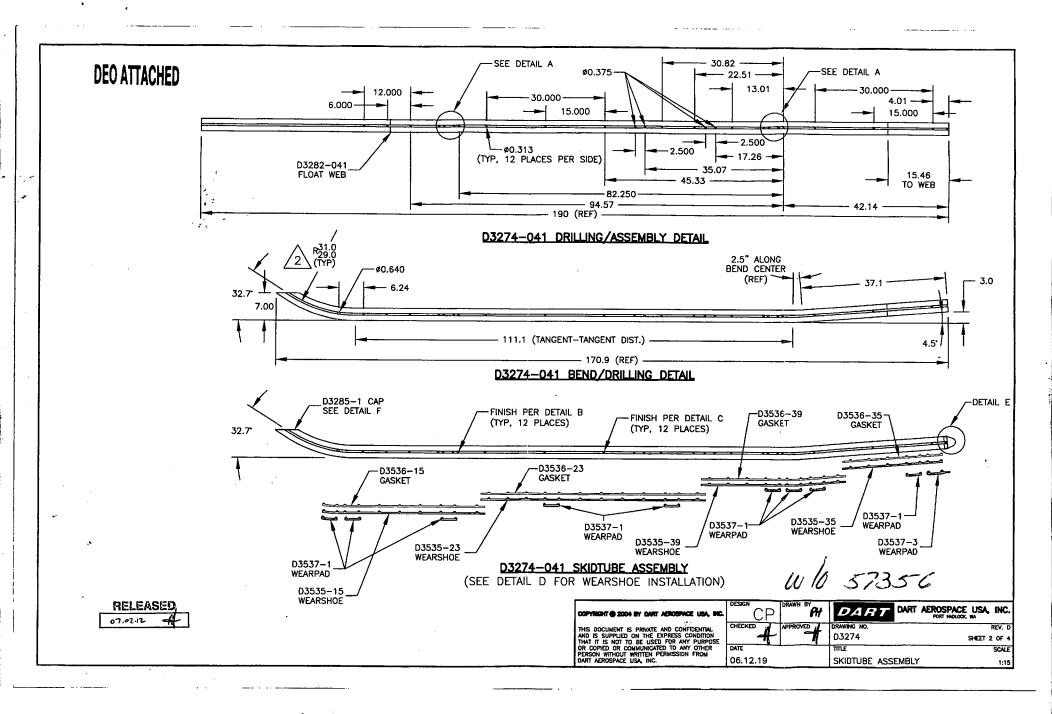
WASHER

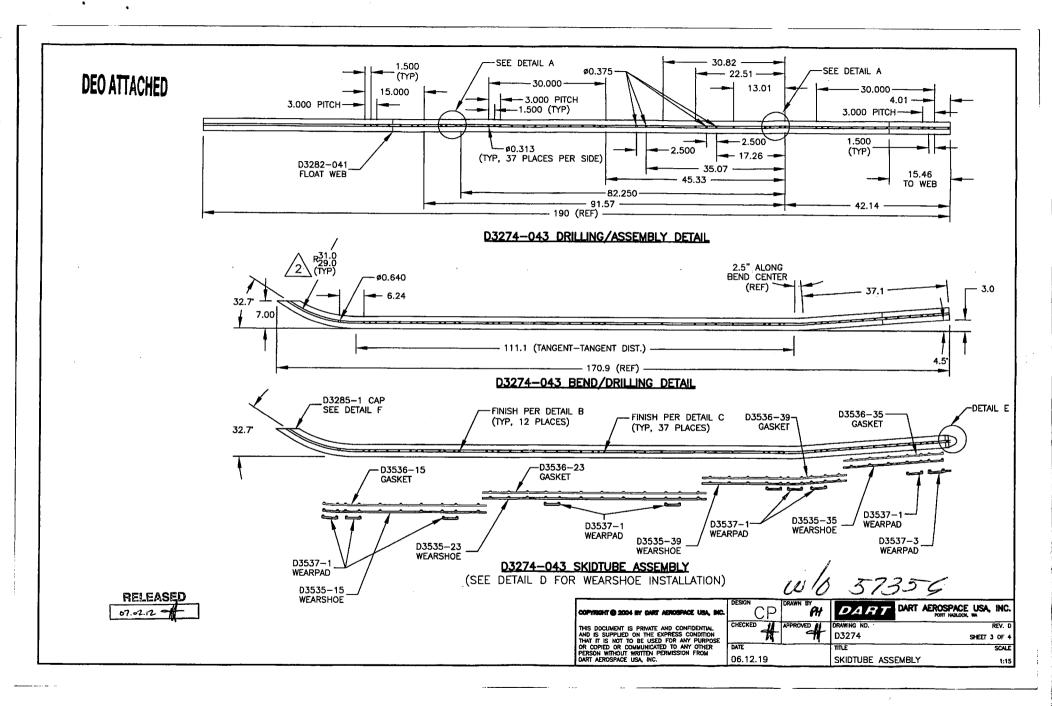
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
  - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

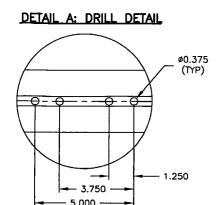
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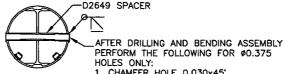








**DETAIL B**FOR Ø0.375 HOLES ONLY

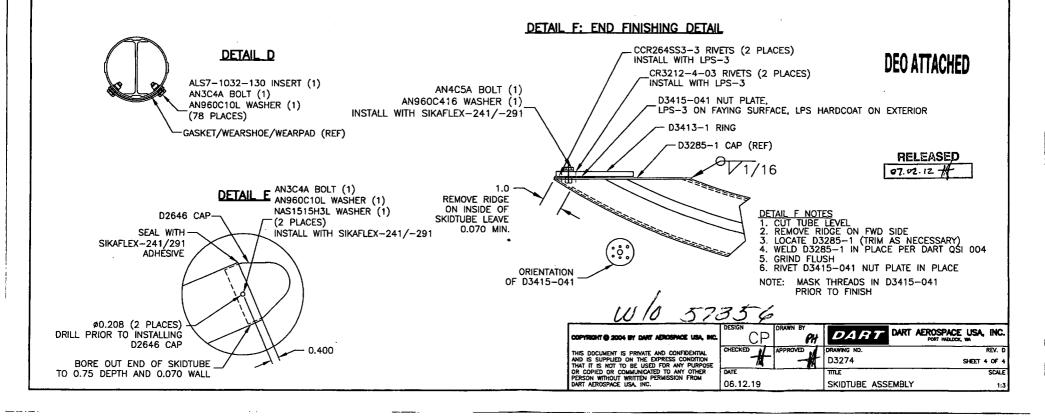


- 1. CHAMFER HOLE 0.030x45° 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

FOR Ø0.313 HOLES ONLY

D3275-1 SPACER

CHAMFER 0.030x45\*



DRAWING I	NO. TITLE	, RI	REV. D DART AEROSPACE USA,	NC D.E.O. NO.	SHEET NO.	SCALE
D3274	SKID	TUBE ASSEMBLY	ENGINEERING ORDER	D3274-D-1	SHEET 1 OF 1	NTS
DRAWN	A	CHECKED	MFG. APPR.	APPROVED , M	DE APPR.	
DATE	09.06.17	DATE 09.06.23	DATE 59/06/23	DATE 09/06/23	DATE 09.06.23	

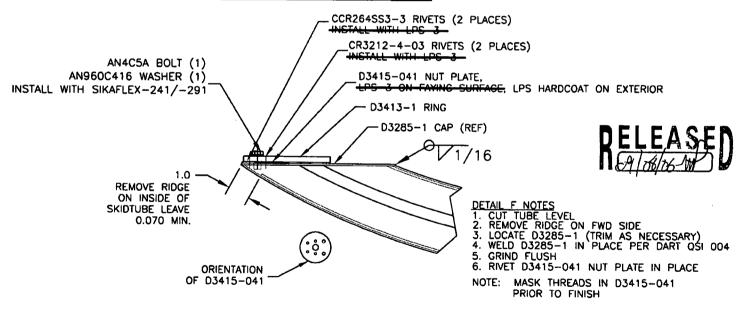
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

#### **DETAIL F: END FINISHING DETAIL**



W/0 57356

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NO.	220	
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# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott	
Job number: 57356	
Part number: Dack-1612 - 541	
Description: Noat tube	
Welding Process: Tig Mig ]	
Base materiel: Aluminium	
Current: AC DC ]	

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[V] fail[] pass[Y] fail[]
<u>UNACCEPTABLE</u>	•
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[v] fail[] pass[v] fail[] pass[v] fail[] pass[v] fail[] pass[v] fail[] pass[v] fail[]
Qualifier Kod W	Date of Test Coupon 10.05.05
Welder Borday Ellist	_ Date of Test Coupon_/0-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld